



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3211-1
Job Sheet 170438



Part No: D3211-1

Job Qty: 5 ea

Part Name: Bracket For Interior Window For -015 & -025



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/16/18

Job Tracking No:

Due Date: 1/31/18

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG REV B IPP Rev:A New Issue 05-11-17 JLM IPP Rev:B Now on Waterjet 06-10-24 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea		1/30/18	0.00	0.00	Start Up Waterjet		DE 18/02/019
100	Waterjet	6 pcs		1/30/18	0.00	1.29	Waterjet1		DE 18/02/019
120	QC	6 pcs		1/30/18	0.00	0.00	QC8		DE 18-2-15
130	Small Fab	6 pcs		1/30/18	0.00	0.00	Small Fab-3		SK
140	Brake NC	6 pcs		1/30/18	0.04	0.80	Brake NC 1		DAS B
150	QC	6 pcs		1/30/18	0.00	0.00	QC5		38
160	HandFinish	6 pcs		1/30/18	0.00	0.32	HandFinish1		18-02-15
170	Powdercoat	6 pcs		1/31/18	0.00	0.19	Powdercoat4		BR 18-2-15
180	QC	6 pcs		1/31/18	0.00	0.00	QC3		38
190	Packaging	6 pcs		1/31/18	0.00	0.00	Packaging3-1		FEB 16 2018
200	QC21-SA	6 Ea		1/31/18	0.00	0.00	QC21		DAS 21 3-60

Part Op 100 - 1-Cut as per Dwg D3211
Descriptions: 130 - Deburr
140 - Bend D3211-1 Stack as per Dwg D3211
170 - START TIME: 0:45 00:1:30 FINISH: 11:15 M 138700.

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M2024T3S.063	8	321	0	0

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order: _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐
Part No. _____	
NCR No. _____	

Date : _____	Step #: _____
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Description Work Order Deviation

Dart Aerospace Ltd.
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Email: sales@dartaero.com
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Engineering	☐
Quality	☐
Other	☐

MRB (QSI042) Approval

Completed By

Hand / Supervisor
Approval Verification

QA Coordinator
Approval

Root Cause	
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐

Pressure/Forced	☐
Bending	☐
Centre Not Concentric	☐
Cracks	☐
Crimp/Kink/Ripple/Wave	☐
Cuffs	☐
Crushing	☐
Heat Treat	☐
Wave/Twist in Tube	☐
Marks/Chatter	☐

Temperature	☐
Set-up	☐
BOM/Route	☐
Broken/Damaged	☐
Inspection In	☐
Contaminated	☐
Countersink	☐
Cut Too Short	☐
Instructions Incorrect	☐
Drill Holes	☐

DART
AEROSPACE
S039786



Bracket For Interior Window For -015 & -025

D3211-1

PART NO: S039786

Original Serial #:

Revision:

Operation:

Change No:

Start up Operation 02/07/18
Job No: 170438

Misaligned	☐
Fit/Function	☐
Misaligned/off center	☐

Drawing	☐
Finish	☐
Misread	☐
Turning Sequence	☐

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Bracket	0.250inches $\pm$ 0.030	0.280 0.220		
2	Bracket	1.910inches $\pm$ 0.030	1.940 1.880		
3	Bracket	0.128inches + 0.005 - 0.000	0.133 0.128		
4	Bracket	0.141inches + 0.005 - 0.000	0.146 0.141		
5	Bracket	17.710inches $\pm$ 0.030	17.740 17.680		
6	Bracket	1.910inches $\pm$ 0.030	1.940 1.880		
7	Bracket	1.560inches $\pm$ 0.030	1.590 1.530		
8	Bracket	11.320inches $\pm$ 0.030	11.350 11.290		

Plex 1/16/18 12:46 PM dart.lacelle.linda

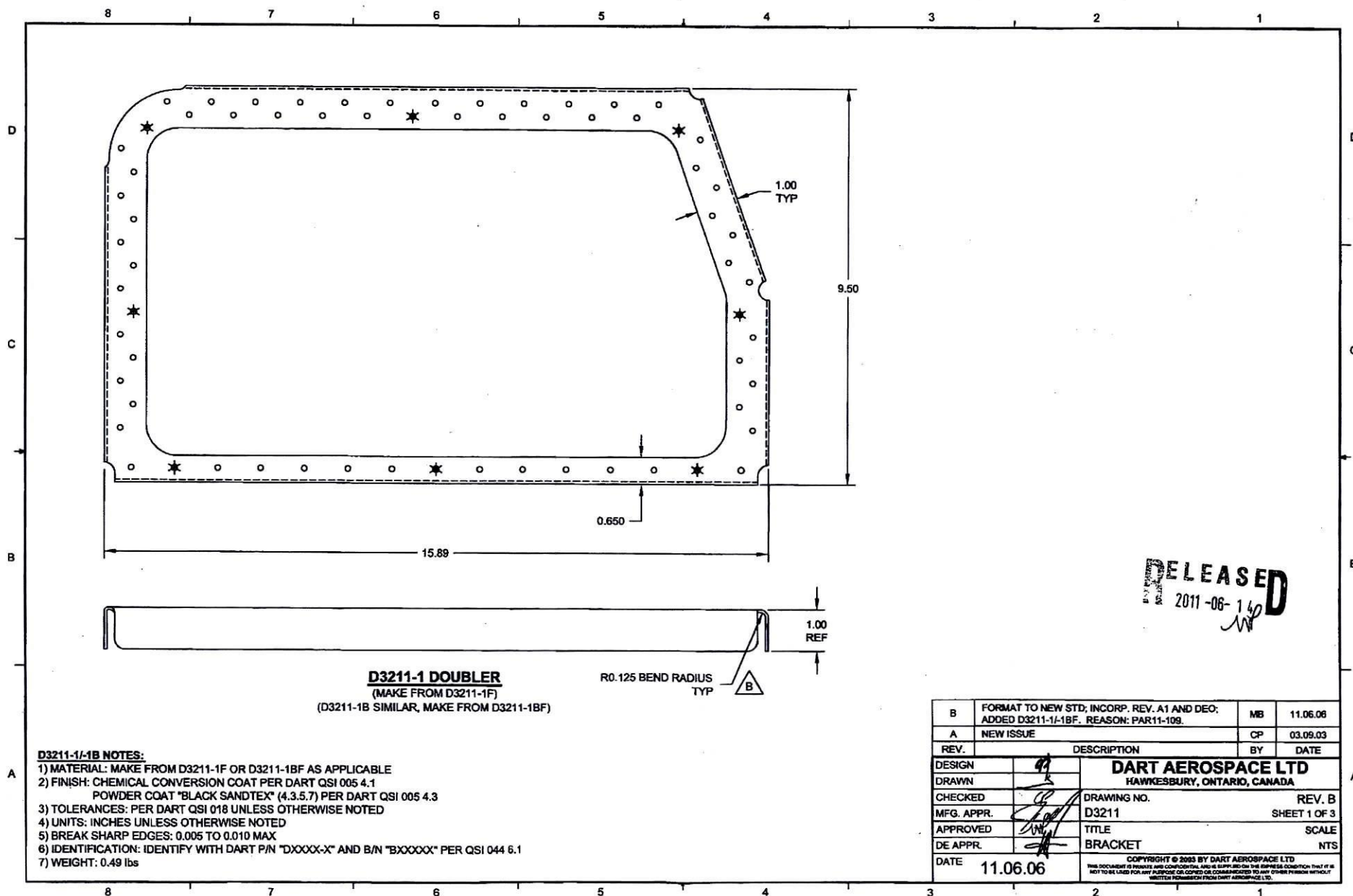
DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								



RELEASED
2011-06-14

B	FORMAT TO NEW STD; INCORP. REV. A1 AND DEO; ADDED D3211-1/1B. REASON: PAR11-109.	MB	11.06.06
A	NEW ISSUE	CP	03.09.03
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.06.06		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3211
REV. B
SHEET 1 OF 3

TITLE BRACKET
SCALE NTS

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